



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4092-1

Job Sheet 167337



Part No: D4092-1

Job Qty: 20 ea

Part Name: Maintenance Step



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/27/17

Job Tracking No:

Due Date: 11/24/17

Created By: Linda Lacelle

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		11/23/17	0.00	0.00	Start Up Machining		SL
100	Bandsaw	20 pcs		11/23/17	0.00	1.14	Bandsaw1		SL
110	CNC Vertical Machining	20 pcs		11/23/17	0.27	18.18	HAAS 1		SL
120	QC	20 pcs		11/23/17	0.00	0.00	QC2		SL
130	QC	20 pcs		11/23/17	0.00	0.00	QC8		SL
140	HandFinish	20 pcs		11/23/17	0.00	2.21	HandFinish1		2017-12-06 JSC
155	HandFinish	20 pcs		11/24/17	0.00	2.21	HandFinish3		BEB 11/21/17
160	QC	20 pcs		11/24/17	0.00	0.00	QC3		38
170	Packaging	20 pcs		11/24/17	0.00	0.00	Packaging3		5m
180	QC21-SA	20 Ea		11/24/17	0.00	0.00	QC21		DEC 15 2017

Part Op 110 - Mill as per Dwg and Folio FA935 ****Grind flush transition machining mark after machining bottom of extrusion, see Descriptions: detail A.****

SL 450

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2761-108	50	2,583	0	0

30 1/2 Long

Part Specifications

F140540

Specifications could not be found.

S012293

S017215

Plex 11/1/17 10:48 AM dart.Michaud-Febrille.Victoria

S 012669

BEB wing walk M138423

DART
AEROSPACE

S012669



Maintenance Step

PART NO:
Revision:
Operation:
Change No:

D4092 - 1

Bandsaw

Mfg Date: 11/22/17
Job No: 167337

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DART AEROSPACE LTD		Work Order: 167 337
Description: Maintenance Step		Part Number: D4092-1
Inspection Dwg: D4092	Rev: C	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
30.06	+/-0.030	30.06	✓		TAPE	
0.19	+/-0.030	0.185	✓		Ver EDG	
1.25	+/-0.030	1.245	✓		Ver CNGO2	
1.38	+/-0.030	1.379	✓		H.G.	
0.25	+/-0.030	0.245	✓		Ver EDG	
R0.25	+/-0.030	R.025	✓		R.G.	
2.50	+/-0.030	2.499	✓		Ver EDG	
Ø0.201	+0.005/-0.001	Ø.201	✓		G.P.	
0.30	+/-0.030	0.30	✓		Ver EDG	
4.78	+/-0.030	4.779	✓		H.G.	
1.69	+/-0.030	1.69	✓		Ver EDG	
2.96	+/-0.030	2.96	✓		Ver CNGO2	
0.030	+/-0.010	0.026	✓		Ver EDG	
0.20	+/-0.030	.190	✓		Ver EDG	
0.50	+/-0.030	.499	✓		Ver EDG	
0.035	+/-0.010	.033	✓		Ver EDG	
0.390 x 100°	+/-0.010 x 0.5°	.384 x 100°	✓		Ver EDG	
1.500	+/-0.130	1.498	✓		Ver EDG	
0.50	+/-0.030	.498	✓		Ver EDG	
1.25	+/-0.030	1.249	✓		Ver EDG	
0.69	+/-0.030	0.69	✓		Ver EDG	
0.38	+/-0.030	0.375	✓		Ver EDG	
0.69	+/-0.030	0.69	✓		Ver EDG	

Measured by: SC.	Checked by: 	QC Inspector:
Date: 17/11/21	Date: 17/12/05	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	12.05.15	New Issue	KJ	
B	13.06.18	Dimension 2.96 was 2.69	KJ	
C	15.11.19	Dwg Rev updated	KJ 	